

**Amendments to the Specification**

**Please replace the paragraph beginning at page 8, line 11, with the following amended paragraph:**

The treatment head 4, together with the clamping roller 10, moves along the outline K in the feed direction 13, acting on the two join partners 1,2, the top outline K in the feed direction 13, acting on the two join partner 1 of which being locally heated by the leading secondary radiation in the respective welding area 18. Consequently, for initially melting the top partner 1, less heat energy is needed by the (bottom) absorbing join partner 2 in order to obtain an integral union of the two partners 1, 2 by the lagging laser welding beam 3. Figs. 3 and 4 explain the above effect of the secondary radiation 15. Fig. 3 shows the simulated temperature field of a conventional laser welding process of polyethylene (PE) without secondary radiation. The molten phase, shown as a white area in Fig. 3, extends primarily in the bottom, absorptive join partner 2<sub>1</sub>, its extension in the top, transmissive join partner 1<sub>2</sub> being inferior. This means that the process window is very narrow, any integral union by the welding process window being no longer ensured when the conditions of heat transfer from the bottom join partner 1 to the top join partner 2 deteriorate only slightly. A reason therefor may for instance reside in increased welding gaps.